

Work Order ID 50481

July 10, 2009 2:31:13 PM



Page 1

Item ID: D3828-2KIV

Accept



Setup Start

Revision ID: A-PROTO

Item Name: Vertical Tunnel Lower, RH

Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mf

Date: 09-07-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|------------------|
| D3828 | A-PROTO-09.06.12 |

100 0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/14 (X1)

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA053 using tool DT9073
Dwg Rev: A
Folio Rev: A

M109703

BB 09/07/14 (X1)

100

Page 2

Accept

[illegible]**Setup Start**

Stop

15 of 15

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

| Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

120

QC2- Inspect parts off machine FAI/FAIB

0.00

[REDACTED]

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00

00000000000000000000000000000000

QC

Memö

0.00

Quality Control

140

0.00

SECRET

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

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Item ID: D3828-2KIV

Accept

Revision ID: A-PROTO

Item Name: Vertical Tunnel Lower, RH

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

Sl. 09/02/15 (x1)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

RH 09.07.20

ENGINEERING
APPROVAL

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

FOR ENG'G TEST RH 09.07.20

ENGINEERING
1941

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Item ID: D3828-2KIV

Accept



Setup Start



Revision ID: A-PROTO

Item Name: Vertical Tunnel Lower, RH

Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.07.20 Prototype

24-0708

Picklist Print

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Page 1

Work Order ID: 50481

Parent Item: D3828-2KIVRevA-PROTO

Parent Item Name: Vertical Tunnel Lower, RH

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MKYD5185S.080-P3- 62015 | | Purchased | No | | | 100 | sf | 894.5038 | 2.6250 | | | |



6185 KYDEX .080"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

109703

894.5037653

894.503765

M109703
BB 09/07/09 XI

| | |
|--------------------------------------|--------------------------|
| DART AEROSPACE LTD | Work Order: 50481 |
| Description: | Part Number: D.3828-2K14 |
| Inspection Dwg: D3828-2 Rev: A PROTO | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than _____" | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

Measured by: DR

Date: 09/07/16

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------------|-------------------|------------------|--------|--------|----------------------|----------|
| 4.5" | ± .100 | 4.5" | ✓ | | | |
| .5" | ± .100 | .562" | ✓ | | | |
| .9" | ± .100 | .903" | ✓ | | | |
| 1.0" | ± .100 | 1.028" | ✓ | | | |
| 0.040" 0.050 | ± .010 | 0.058" | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

RA
09.07.20

Measured by: D.berger

Date: 09/07/15

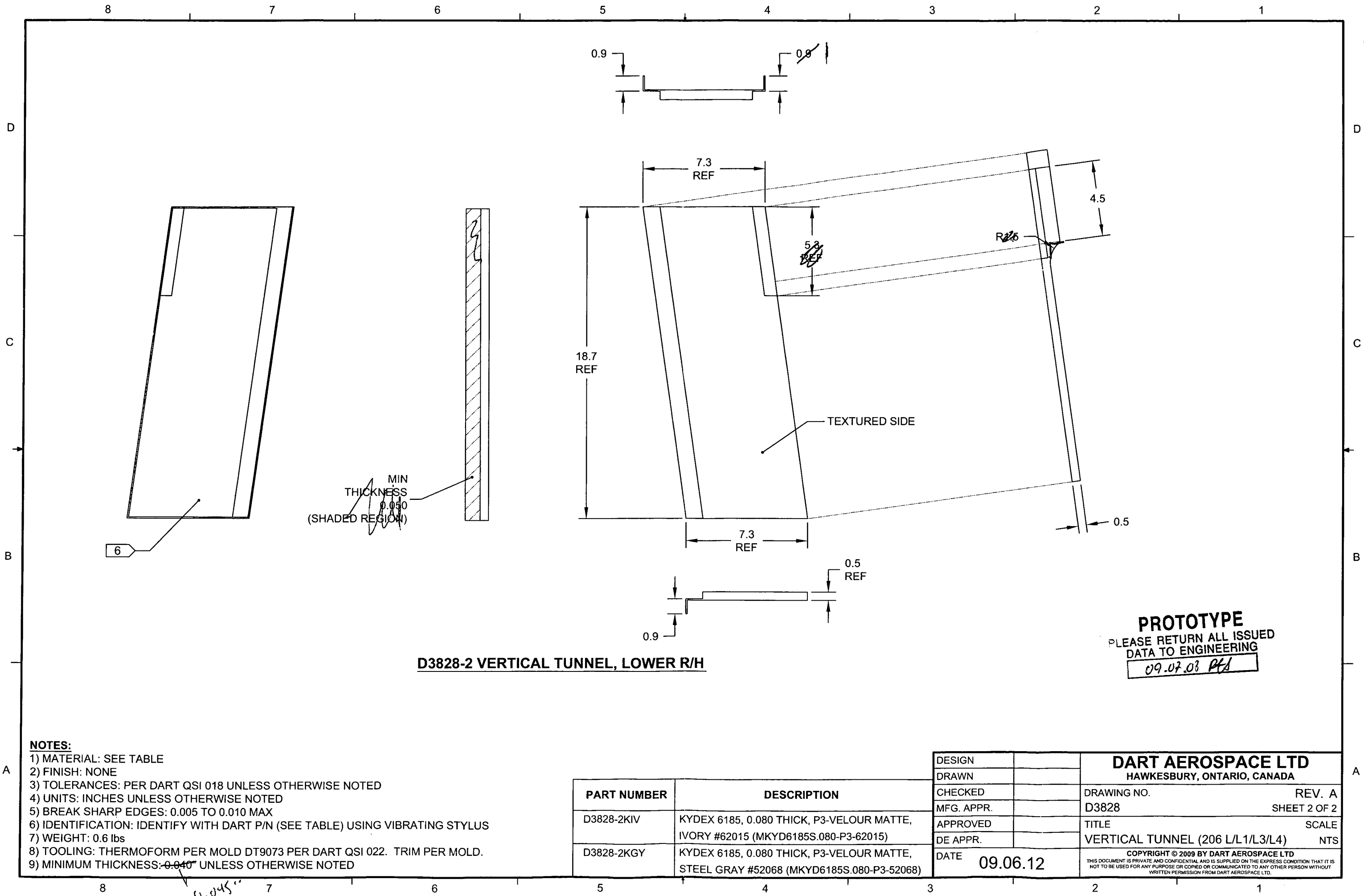
Audited by: PH

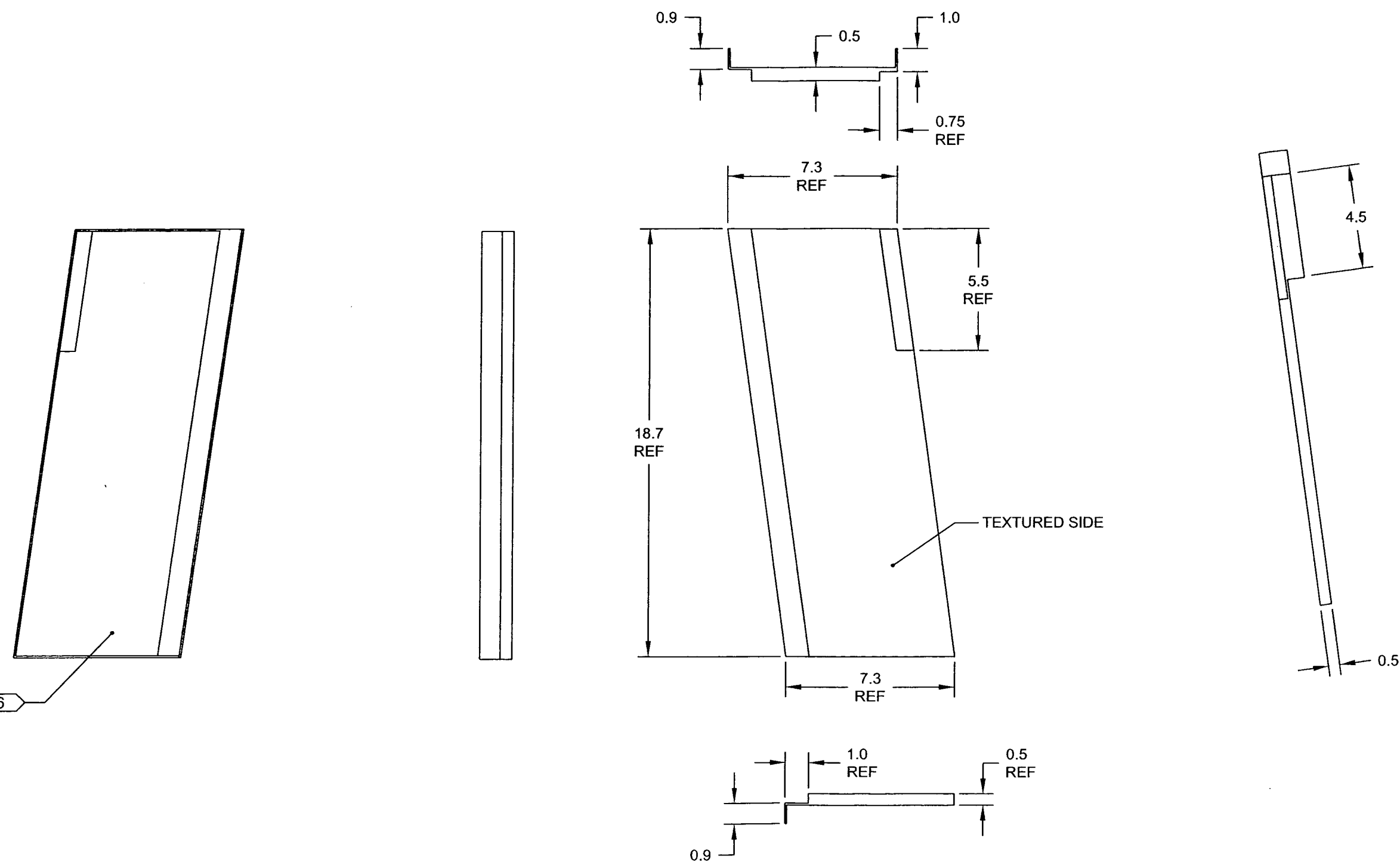
Date: 09.07.17

Prototype Approval: PH

Date: 09.07.17

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/DL | |





D3828-2 VERTICAL TUNNEL, LOWER R/H

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.6 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9229 PER DART QSI 022. TRIM PER MOLD.
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

| PART NUMBER | DESCRIPTION |
|-------------|--|
| D3828-2KIV | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015) |
| D3828-2KGY | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

| | | |
|------------|----------|--|
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. REV. A |
| MFG. APPR. | | D3828 SHEET 2 OF 2 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | VERTICAL TUNNEL (206 L/L1/L3/L4) NTS |
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